

Work Order ID 56554

Monday, March 01, 2010 2:54:00 PM



Page 1

Item ID: D3763-041

Revision ID:

Item Name: End Fitting Assembly

Start Date: 3/1/2010 Start Qty: 16.00

Required Date: 3/15/2010 Req'd Qty: 16.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: *mf*

Date: *10-3-1*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3763

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

(X16)

Pl 10.03.16

110

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble as per dwg D3763 using locating pin DT9039*****ensure locating pin is in 0.221" hole***** 3-weld as per dwg D3763 QSI004 Alum. rod Batch: *17112860*

(X16)

Pl 10.03.16

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 10.03.16
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 03763-041 PAR #: _____ Fault Category: Large FAS NCR: Yes No DQA: 1 Date: 10-03-18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>56554</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/18	# 120	Found at welding inspection Qty x5 with cracks in the 03763-3 From welding R.C. Process	<u>[Signature]</u> 10/03/18	Scrap + Destroy Qty x5 No Replace	<u>[Signature]</u> 10-03-18	<u>S</u> 10/03/18	<u>[Signature]</u> 10/03/18	<u>S</u> 10/03/18

NOTE: Date & initial all entries

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Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

S 10/03/10

0.00

X10

X5

QC

Quality Control

Memo

140

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/03/10

0.00

X10

7

HandFinish

Hand Finishing

Memo

150

QC3- Inspect Part Finish

0.00

0.00

QC

Quality Control

Memo

P 10/03/10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Start Date: 3/1/2010 Start Qty: 16.00

Required Date: 3/15/2010 Req'd Qty: 16.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 257A

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/4/22 (11)

10/03/24

10-302 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56554

Parent Item: D3763-041

Parent Item Name: End Fitting Assembly

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Date: 3/1/2010

Required Date: 3/15/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	13.0000	16.0000			



End Fitting

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

54364

11

54433

2

Manufactured No

110

Each

12.0000

16.0000



GL 10-03-15

B56755 → (16) GL

D3763-3



Tube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST251

12

55344

6

56313

6

B56597 → (4)

(6) (6)

GL 10-03-15

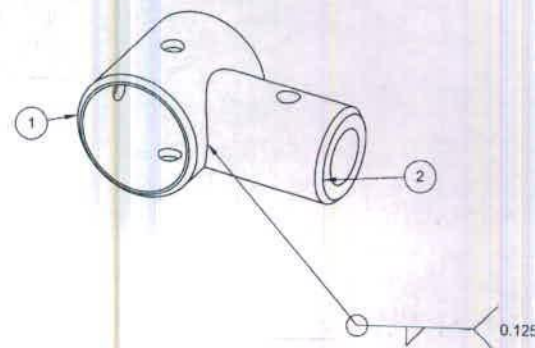
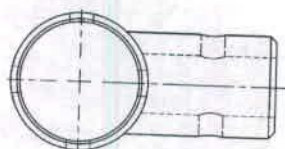
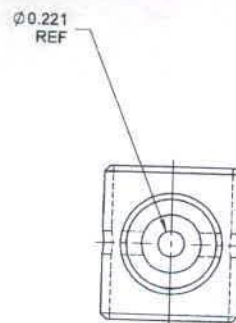
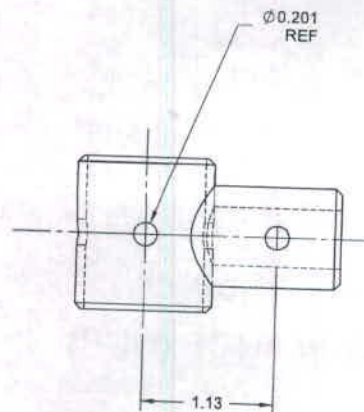
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3763
TITLE
END FITTING
REV. B
SHEET 1 OF 9
SCALE
NTS

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1#56554

RELEASED
08-07-10-11-12

W/O:		WORK ORDER CHANGES					
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